Date: Monday, 13/04/2009 10:17:31 AM
User: Chantal Lavoie

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 47124
Estimate Number : 10498
P.O. Number :
This Issue : 13/04/2009 **S.O. No.** :
Prsht Rev. : NC
First Issue : / / **Type** : SKIDTUBES
Previous Run : 46959
Written By :
Checked & Approved By : CL 9/04/13
Comment : Est Rev: C 02.11.28 Reformat KJ
Est Rev: D 06-03-21 As Per Rev C JLM
Est Rev: E 07-07-28 As per Rev D JLM Verified By:

Drawing Name : WEB
Part Number : D2739
Drawing Number : D2739 REV D
Project Number : N/A
Drawing Revision : D
Material :
Due Date : 20/04/2009 **Qty:** 8 **Um:** Each

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	D26005108	Extrusion `I Beam' thin

Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
Extrusion `I Beam' thin
Pick:
Qty Part Number Description Batch
1 D2600-5 Web B-38589

AWM 9-4-13 (8)

2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1

Comment: LANDING GEAR RESOURCE 1
1-Cut D2600-5 to length as per Dwg D2739.

2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739 (8)

3-Use uni-bit to open holes to finish size as per Dwg D2739.

4-Bevel Fwd end of extrusion and Deburr holes and ends. PW

5-Dburr

AWM 9-4-13

3.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP 9-4-13 (8)

Form: rprocess

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2739 PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: [signature] Date: 09/04/15

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: 47124		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B: Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
05.04.13	2.4	Barrel was 1st done in the incorrect end. R.C: Human error.	[signature] 05/04/13	- Acceptable - barrel other end as per dwg	[signature] 9-4-13	[signature] 9-4-13	[signature] 05/04/13	[signature] 05.04.13

NOTE: Date & initial all entries

Date: Monday, 13/04/2009 10:17:31 AM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** WEB

Job Number: 47124 **Part Number:** D2739

Job Number:

Seq. #:	Machine Or Operation:	Description :
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1
Acid etch and Alodine as per QSI 005 4.1 AWM 9-4-13 (8)

5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION BE 9-14-13 (8)

6.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Use a red or black lead-free paint pen to write the part number and batch number in the middle of each web.

Identify and Stock Location: L-G. AWM 9-4-13 (8)

7.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE 09/04/14

Job Completion

le 09.04.14

Form: rprocess

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

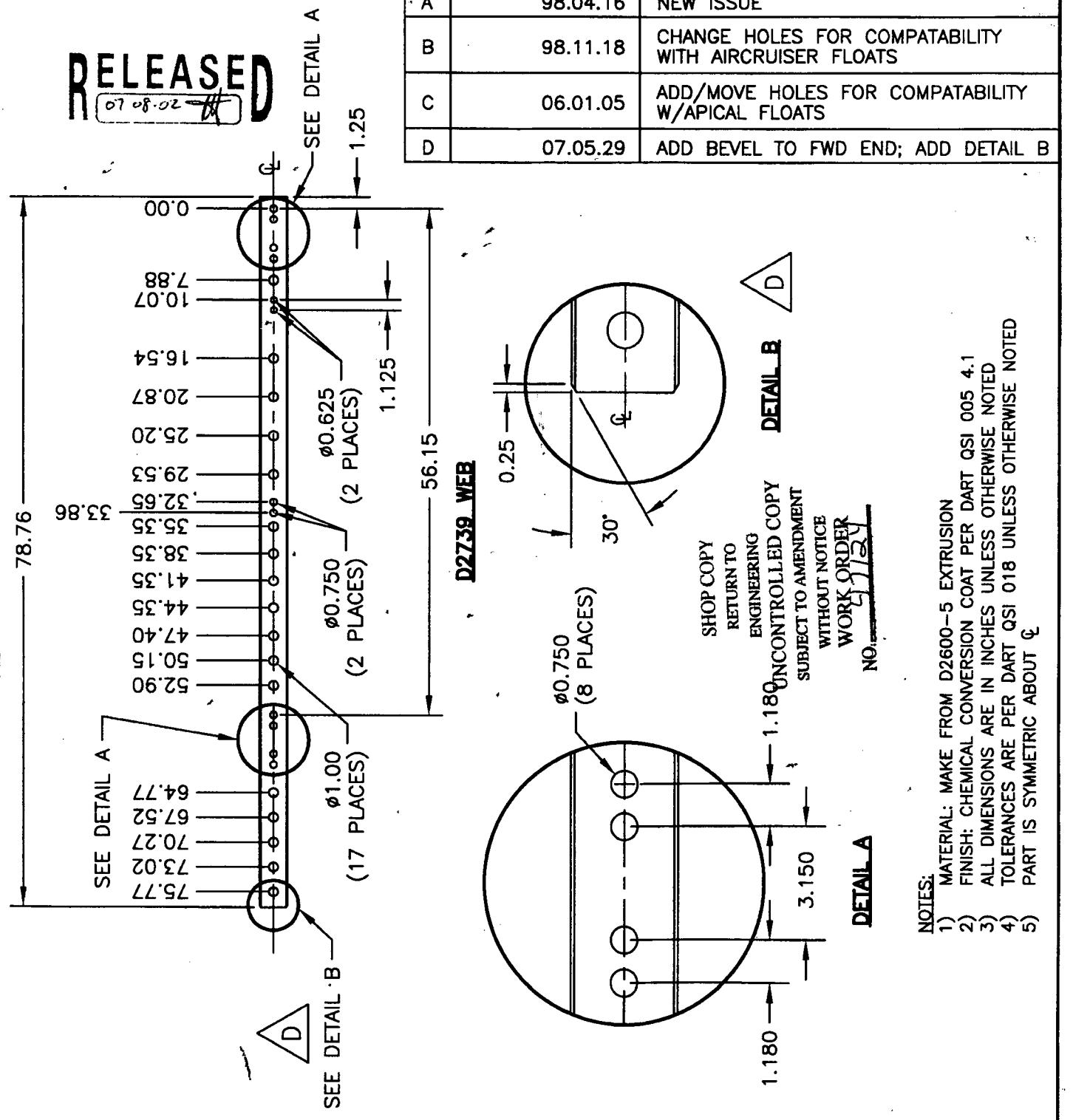
NOTE: Date & initial all entries

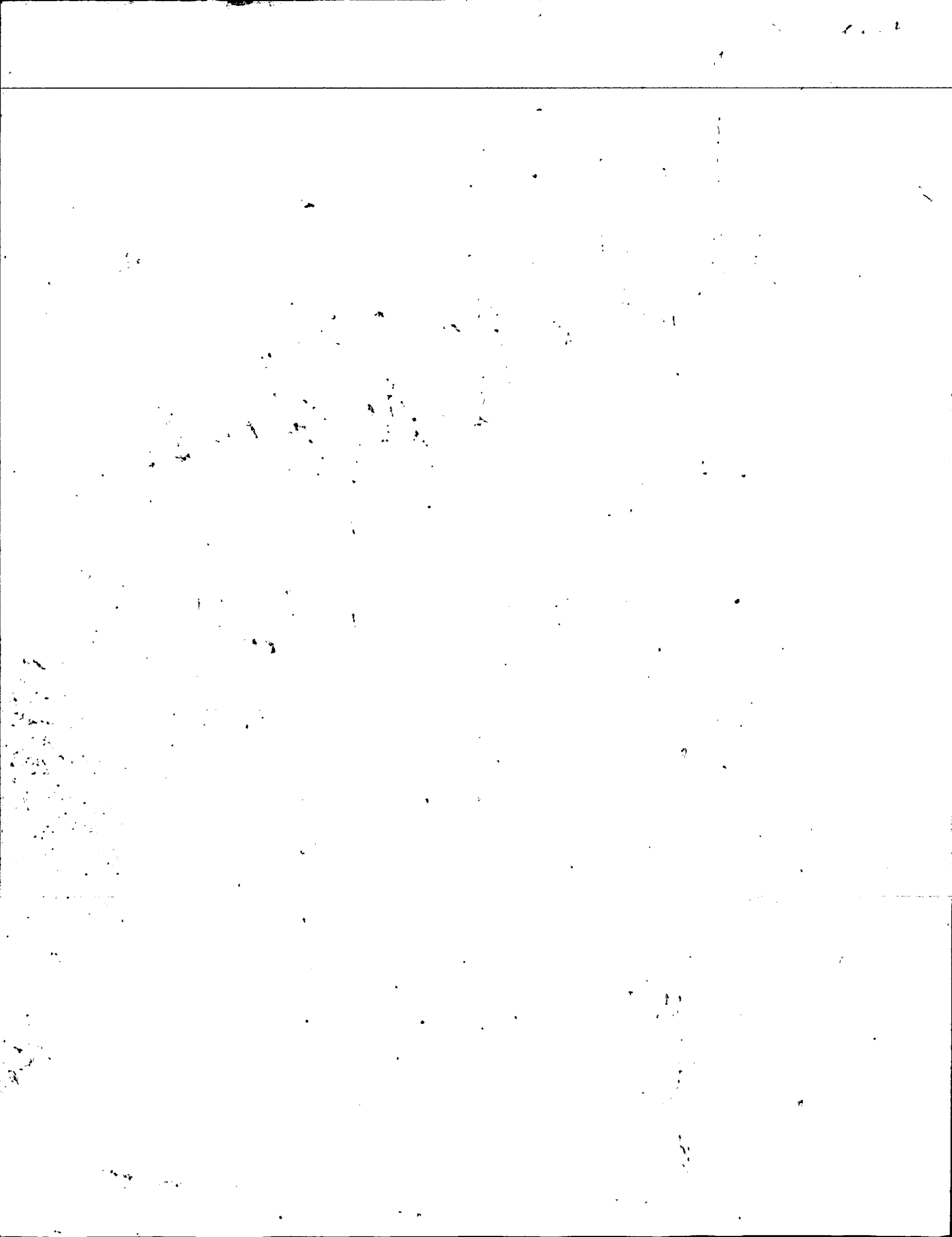
DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
PH	CB		
CHECKED	APPROVED	DRAWING NO.	REV. D
PH		D2739	SHEET 1 OF 1
DATE		TITLE	SCALE
07.05.29		WEB	1:15

A	98.04.16	NEW ISSUE
B	98.11.18	CHANGE HOLES FOR COMPATABILITY WITH AIRCRUISER FLOATS
C	06.01.05	ADD/MOVE HOLES FOR COMPATABILITY W/APICAL FLOATS
D	07.05.29	ADD BEVEL TO FWD END; ADD DETAIL B

RELEASED
07 08.02



NOTES:
1) MATERIAL: MAKE FROM D2600-5 EXTRUSION
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) PART IS SYMMETRIC ABOUT ℄

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